



Thank you for purchasing Arrow Connecting Rods. Great care has been taken to manufacture and deliver the ultimate Connecting Rod for each and every one of our clients.

All areas of the rod have been rumbled and peened to create a compressed hardened layer. Removal of this layer will cause a stress concentration, possibly leading to failure. We therefore recommend that you don't attempt to modify or polish rods.

## Connecting Rod Bolt Installation Instructions

To achieve correct bolt pre-load and to ensure big end bore roundness after re-assembly.

- Ensure mating faces are wiped clean
- Remove any old grease from threads of bolts and rod.
- Apply ARP moly assembly lubricant to seating face of bolt and threads of bolt and rod.
- Assemble cap to rod
- Torque to 15ft/lbs (20Nm).
- Tighten each bolt to recommended stretch value i.e. Loosen first bolt, zero stretch gauge, tighten until correct stretch is achieved. Loosen second bolt, zero stretch gauge, and tighten until correct stretch is achieved.

PLEASE NOTE: To optimise accuracy of the big end bore size and roundness, and to achieve correct bolt pre-load, each bolt should be stretch gauged. A torque wrench setting is given as a guide ONLY.

BOLT LETTER	PART No.	MATERIAL	THREAD	UHL	STRETCH (RECOMMENDED)	TORQUE (NOT RECOMMENDED)
a	3AG1.500-10U	ARP 625+	5/16" UNJF	1.500"	0.0055" - 0.0060"	32 ft/lbs (43Nm)
b	4AJ1.600-10SLU	ARP 625+	3/8" UNJF	1.600"	0.0065" - 0.0070"	46 ft/lbs (62Nm)
c	5AP1.750-10SLU	ARP 625+	7/16" UNJF	1.750"	0.0065" - 0.0070"	85 ft/lbs (115Nm)
d	3AG1.505-2U	ARP 2000	5/16" UNJF	1.505"	0.0050" - 0.0055"	30 ft/lbs (41Nm)
e	4AJ1.500-2SU	ARP 2000	3/8" UNJF	1.500"	0.0055" - 0.0060"	44 ft/lbs (60Nm)
f	4AJ1.750-2SU	ARP 2000	3/8" UNJF	1.750"	0.0065" - 0.0070"	42 ft/lbs (57Nm)
g	4AP1.550-2LU	ARP 2000	7/16" UNJF	1.550"	0.0050" - 0.0055"	66 ft/lbs (90Nm)
h	AR502-2SLU	ARP 2000	7/16" UNJF	1.725"	0.0065" - 0.0070"	65 ft/lbs (88Nm)
j	AR301-2W	ARP 2000	5/16" UNJF	2.125"	0.0070" - 0.0075"	28 ft/lbs (38Nm)
k	3AG1.500-7U	ARP 3.5	5/16" UNJF	1.500"	0.0055" - 0.0060"	30 ft/lbs (41Nm)
m	3AG1.260-10U	ARP 625+	5/16" UNJF	1.260"	0.0045" - 0.0050"	TBC
n	4AJ1.600-2SU	ARP 2000	3/8" UNJF	1.600"	0.0055" - 0.0060"	48 ft/lbs (65Nm)
t	4AJ1.500-10SU	ARP 625+	3/8" UNJF	1.500"	0.0060" - 0.0065"	42 ft/lbs (57Nm)
u	4AJ1.600-7SLU	ARP 3.5	3/8" UNJF	1.600"	0.0055" - 0.0060"	TBC
v	4AJ1.700-2U	ARP 2000	3/8" UNJF	1.700"	0.0065" - 0.0070"	45 ft/lbs (61Nm)
w	2AL1.400-7U	ARP 3.5	1/4" UNJF	1.400"	0.0045" - 0.0050"	TBC
x	M10AM1.575-7U	MP35N	MJ10 x 1.0	1.575"	0.0055" - 0.0060"	TBC
y	M10AI1.950-10U	ARP 625+	MJ9 x 1.0	1.950"	0.0090" - 0.0095"	60 ft-lbs (81Nm)
aa	M10AI1.440-2U	ARP 2000	MJ9 x 0.75	1.440"	0.0050" - 0.0055"	45 ft/lbs (61Nm)
ab	CRB002.9.1.39.BH10.01	MP35N	MJ9 x 1.0	1.535"	0.0055" - 0.0060"	TBC
ac	M10AF1.650-2U	ARP 2000	MJ8 x 1.0	1.650"	0.0065" - 0.0070"	TBC

